

5/22

Split - A

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23190</b>
<b>Description: Pedal Assembly</b>	<b>Part Number:</b>	<b>D3204-041</b>
<b>Dwg: D3204 Rev. A</b>	<b>Qty:</b>	<b>4</b>
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D3204-041 Pedal Assembly D3204-1 Tube D3204-7 Bushing <b>Dwg not required</b>			
		Batch: <u>23190</u> <u>23190</u> <u>23190</u>			
			HJ	05.07.6	4
2	MV	Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) <b>Identify for D3204-3</b>			
		Batch: <u>M11037</u>	SD	05.07.07	10
3	MV	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250) <b>Identify for D3204-5</b>			
		Batch: <u>M7321</u>	SD	05.07.07	10
4	MV	Cut blank: 1.00" x 0.500" x 1.150" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x01.000) <b>Identify for D3204-11</b>			
		Batch: <u>M110973</u>	SD	05.07.07	10
5	MV	Cut blank: 2.000" x 0.375" x 3.100" long Bar Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x02.000) <b>Identify for D3204-9</b>			
		Batch: <u>M5185</u>	SD	05.07.07	10
6	MV	Machine D3204-3 as per Folio FA344 and Dwg D3204 <b>Identify as D3204-3</b>			
			SD	05.07.07	10
7	QC2	Inspect parts as they come off the CNC machine			
			SD	05.07.07	16
8	MV	Deburr			
			SD	05.07.07	10
9	QC8	Second check			
			BE	05.07.08	10
10	MV	Machine D3204-5 as per Folio FA344 and Dwg D3204 <b>Identify as D3204-5</b>			
			SD	05.07.08	10
11	QC2	Inspect parts as they come off the CNC machine			
			SD	05.07.08	10
12	MV	Deburr			
			SD	05.07.08	10
13	QC8	Second check			
			BE	05.07.08	10
14	MV	Machine D3204-11 as per Folio FA357 and Dwg D3204 <b>Identify as D3204-11</b>			
			SD	05.07.08	10
15	QC2	Inspect parts as they come off the CNC machine			
			SD	05.07.08	10
16	MV	Deburr			
			SD	05.07.08	10
17	QC8	Second check			
			BE	05.07.08	10
18	MV	Machine D3204-9 as per Folio FA357 and Dwg D3204 <b>Identify as D3204-9</b>			
			BE	05.07.09	10
19	QC2	Inspect parts as they come off the CNC machine			
			BE	05.07.09	10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23190
<b>Description:</b> Pedal Assembly		<b>Part Number:</b>	D3204-041
<b>Dwg:</b> D3204 Rev. A		<b>Qty:</b>	4
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty															
20	MV	Deburr	RG	05.07.09	10															
21	QC8	Second check	CR	05.07.09	10															
22	WA	<b>Cut (2) D3204-13 per Assembly</b> Cut blanks as per Dwg D3204 Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) <b>Identify as D3204-13</b> Batch: M15120 M17695	CPL	05.07.14	10															
23	WA	Grind hypotenuse side	CPL	05.07.14	10															
24	WA	Weld assembly as per Dwg D3204 using Jig D3204-041T1 <b>Pick:</b> <u>D3204-1</u> B23190 B23524 <table><tr><th>Qty</th><th>Part Number</th><th>Description</th></tr><tr><td>-3</td><td>B21783</td><td>B23190</td></tr><tr><td>-5</td><td>B21783</td><td>B23190</td></tr><tr><td>-9</td><td>B21783</td><td>B23190</td></tr><tr><td>-11</td><td>B23190</td><td></td></tr></table> <b>Identify as D3204-041</b>	Qty	Part Number	Description	-3	B21783	B23190	-5	B21783	B23190	-9	B21783	B23190	-11	B23190		CPL	05.07.14	10
Qty	Part Number	Description																		
-3	B21783	B23190																		
-5	B21783	B23190																		
-9	B21783	B23190																		
-11	B23190																			
25	QC5/9	Inspect weld	DA	05/07/14	10															
26	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.14	10															
27	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3204-041 <b>Note: Cover holes for bushing</b>	FC	05/07/14	10															
28	QC3	Inspect Powder Coat	SD	05/07/15	10															
29	GA	Install D3204-7 bushing as shown in Dwg D3204 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3204-7</td><td>Bushing</td><td>B21782</td></tr></table>	Qty	Part Number	Description	Batch	2	D3204-7	Bushing	B21782	SB	05/07/15	7							
Qty	Part Number	Description	Batch																	
2	D3204-7	Bushing	B21782																	
30	QC5	Inspect work to Step 29	AD	05/07/15	7															
31	ST	Identify and Stock D3204-041 Qty: 3 D3204-1 Qty: _____ D3204-7 Qty: _____ <b>Note: D3204-1/-7 are stocked in welding cell</b>	DC	05/07/15	7															
32	AC	Parts to Stock and Prorate Cost to parts per Step 31 Cost / part 172.62 / 172.62	AP	05/07/15	7															
33	DC	Close W/Order and Ensure Travelers attached Inspect Level 21 Travelers: D3204-041 D3204-1 D3204-7	AP	05/07/15	7															

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Added Travelers	KJ/RF	

RELEASED

14.04.21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05/07/06	24	Permanent change	G			Le	05/07/07	
05/07/15								

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DART AEROSPACE LTD		Work Order: 23190
Description: Arm		Part Number: D3204-3
Inspection Dwg: D3204	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030					
5.25	+/-0.030					
0.776	+/-0.010					
Ø0.760	+0.005/-0.000					
0.080	+/-0.010					
R0.50	+/-0.010					
2.373	+/-0.010					
0.750	+/-0.010					
R0.380	+/-0.010					
Ø0.375	+0.001/-0.000					
0.300	+/-0.010					
Same as 23524 w/o						

Measured by: SD	Audited by: E	Prototype Approval: N/A
Date: 05.07.07	Date: 05.07.08	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	

RELEASED  
05.02.27











# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 06, 2005  
01:05 pm

Work Order No : 0023190  
Project Name : D3204-041  
Project For : WK522  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3204-041  
Description : Pedal Assembly  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 05-05-05  
Est Finish Date : 05-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00

Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	1.00	100.00		
Production Cost :	0.00	13.38	100.00	0.00	13.38
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	1.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	13.38	100.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	13.38			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -13.38)

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23190
<b>Description:</b> Bushing		<b>Part Number:</b>	D3204-7
<b>Dwg:</b> D3204 Rev. A page 2		<b>Qty:</b>	4
<b>Ref:</b>		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	AP	05/05/09	4
2	MC	Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 Material: AISI 303 SS Ø0.50" (M303R0.500) <b>Identify for D3204-7</b> Batch: _____			
3	QC2	Inspect parts as they come off the CNC machine <b>Identify as D3204-7</b>			
4	MC	Deburr			
5	QC8	Second check			
6	MC	Go to D3204-041 for assembly			

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

**RELEASED**

RF 04.06.21



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

5/22

DART AEROSPACE LTD	Work Order:	23190
Description: Tube	Part Number:	D3204-1
Dwg: D3204 Rev. A page 2	Qty:	4
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AP	05/05/09	4
2	MC	Turn D3204-1 tube as per Folio FA356 and Dwg D3204 Material: 6061-T6/-T62 (QQ-A-200/8) Ø0.750" x 0.125" wall (M6061T6T0.750W.125) Identify for D3204-1 Batch: M15972	JG	05/06/06	5
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-1	JG	05/06/06	5
4	MC	Deburr	JG	05/06/06	5
5	QC8	Second check	RF	05.06.06	5
6	MC	Go to D3204-041 for welding	GPL	05.07.12	5

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

RELEASED

RF 04-06-21



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

